2 Operator interface panel

2.1 Malfunction

Code	Designation Reaction/consequences	Cause	Remedy
200	FatalError(), see logbook	Software running error	Note message in data screen 31.30 Switching off the main switch. Contact Rieter Service
201	Control module CX408 fault/defect. A31	Node dial switch adjusted incorrectly	Adjust node dial switch correctly
		No power supply to CAN bus	CAN plug is not connected.
		No data transfer	CAB bus not connected Check CAN bus terminating resistor Check all number switches of all CAN nodes, incl. at converter.
201	CX408 ctrl. module, over-curr.13,14 A31	Excess current, digital output A31	Digital output, excess current or short circuit
201	CX408 ctrl. module, over-curr.15,16, A31	Excess current, digital output A31	Digital output, excess current or short circuit
201	CX408 ctrl. module, no supply inp., A31	No power supply to the digital inputs	A31/X1 plug is not connected Pin 1 or Pin 2, X1 plug is not connected
201	CX408 ctrl. module,no supply outp., A31	No power supply to the digital outputs	A31/X2 plug is not connected Pin 1 or Pin 2, X2 plug is not connected
		Fault with relays K20, K21, K22 or S6	Contacts are not functioning correctly. Relay contacts fail to switch or stick. Replace relays Check wiring
202	Control module CX408 fault/defect. A32	Node dial switch adjusted incorrectly	Adjust node dial switch correctly
		No power supply to CAN bus	CAN plug is not connected.
		No data transfer	CAB bus not connected Check CAN bus terminating resistor Correctly configure machine ☞ 43.1, Page 2/112 Make correct configuration settings for options ☞ 43.2, Page 2/114 Check all CAN node number switches
202	CX408 ctrl. module, over-curr.13,14, A32	Excess current, digital output A32	Digital output, excess current or short circuit
202	CX408 ctrl. module, over-curr.15,16, A32	Excess current, digital output A32	Digital output, excess current or short circuit
202	CX408 ctrl. module, no supply inp., A32	No power supply to the digital inputs	A32/X1 plug is not connected Pin 1 or Pin 2, X1 plug is not connected

Code	Designation Reaction/consequences	Cause	Remedy
202	CX408 ctrl. module,no supply outp., A32	No power supply to the digital outputs	A32/X2 plug is not connected Pin 1 or Pin 2, X2 plug is not connected
		K20 or K22 relay defect-ive	Contacts are not functioning correctly. Relay contacts fail to switch or stick. Replace relays Check wiring
203	Control module CX408 fault/defect. A33	Node dial switch adjusted incorrectly	Adjust node dial switch correctly
		No power supply to CAN bus	CAN plug is not connected.
		No data transfer	CAB bus not connected Check CAN bus terminating resistor Correctly configure machine ☞ 43.1, Page 2/112 Make correct configuration settings for options ☞ 43.2, Page 2/114 Check all CAN node number switches
203	CX408 ctrl. module, over-curr.13,14, A33	Excess current, digital output A33	Digital output, excess current or short circuit
203	CX408 ctrl. module, over-curr.15,16, A33	Excess current, digital output A33	Digital output, excess current or short circuit
203	CX408 ctrl. module, no supply inp., A33	No power supply to the digital inputs	A33/X1 plug is not connected Pin 1 or Pin 2, X1 plug is not connected
203	CX408 ctrl. module,no supply outp., A33	No power supply to the digital outputs	A33/X2 plug is not connected Pin 1 or Pin 2, X2 plug is not connected
		K20 or K22 relay defect-ive	Contacts are not functioning correctly. Relay contacts fail to switch or stick. Replace relays Check wiring
204	Control module CX408 fault/defect. A34	Node dial switch adjusted incorrectly	Adjust node dial switch correctly
		No power supply to CAN bus	CAN plug is not connected.
		No data transfer	CAB bus not connected Check CAN bus terminating resistor Correctly configure machine ☞ 43.1, Page 2/112 Make correct configuration settings for options ☞ 43.2, Page 2/114 Check all CAN node number switches
204	CX408 ctrl. module, over-curr.13,14, A34	Excess current, digital output A34	Digital output, excess current or short circuit

Code	Designation Reaction/consequences	Cause	Remedy
204	CX408 ctrl. module, over-curr.15,16, A34	Excess current, digital output A34	Digital output, excess current or short circuit
204	CX408 ctrl. module, no supply inp., A34	No power supply to the digital inputs	A34/X1 plug is not connected Pin 1 or Pin 2, X1 plug is not connected
204	CX408 ctrl. module,no supply outp., A34	No power supply to the digital outputs	A34/X2 plug is not connected Pin 1 or Pin 2, X2 plug is not connected
		K20, K21 or K66 relay defective	Contacts are not functioning correctly. Relay contacts fail to switch or stick. Replace relays Check wiring
205	Ethernet module fault/defective A18	Ethernet module missing or is defective	Insert missing module or replace defective module
		Incorrect type of card selected	Configure the card correctly ☞ 43.1, Page 2/112 Correctly configure options ☞ 43.2, Page 2/114
207	Control module CX408 fault/defect. A35	Node dial switch adjusted incorrectly	Adjust node dial switch correctly
		No power supply to CAN bus	CAN plug is not connected.
		No data transfer	CAB bus not connected Check CAN bus terminating resistor Correctly configure machine ☞ 43.1, Page 2/112 Make correct configuration settings for options ☞ 43.2, Page 2/114 Check all CAN node number switches
207	CX408 ctrl. module, over-curr.13,14, A35	Excess current, digital output A35	Digital output, excess current or short circuit
207	CX408 ctrl. module, over-curr.15,16, A35	Excess current, digital output A35	Digital output, excess current or short circuit
207	CX408 ctrl. module, no supply inp., A35	No power supply to the digital inputs	A35/X1 plug is not connected Pin 1 or Pin 2, X1 plug is not connected
207	CX408 ctrl. module,no supply outp., A35	No power supply to the digital outputs	A35/X2 plug is not connected Pin 1 or Pin 2, X2 plug is not connected
		K20, K21 or K66 relay defective	Contacts are not functioning correctly. Relay contacts fail to switch or stick. Replace relays Check wiring
208	Control, overheating A10	Insufficient cooling	Lower the ambient temperature
		Other hardware fault	Replace operator interface panel
209	Control module CAN fault/defect. A11	No A11 CAN module	Insert A11 CAN module into A10 panel and fix tight

Code	Designation Reaction/consequences	Cause	Remedy
209	Control module CAN fault/defect. A11	Incorrect parameters set for A11 CAN module	Set node switches X1 to 1 and X2 to 0
		Wrong CAN module inserted	Insert 3IF797.9-1 CAN module
		Contact problems with CAN module	Correctly insert CAN module
		Software running error	Confirm the cleared status of the fault and restart the machine
210	Data loss maintenance data A10	Software running error	Acknowledge the error and restart the machinery.
211	Data loss Shift data A10	Software running error	Acknowledge the error and restart the machinery.
212	Data loss remanent data A10	Software running error	Acknowledge the error and restart the machinery.
213	Data loss Logbooks A10	Software running error	Acknowledge the error and restart the machinery.
214	Data loss statistiks data A10	Software running error	Acknowledge the error and restart the machinery.
215	Data loss grafik data A10	Software running error	Acknowledge the error and restart the machinery.
238	Fault relay, ext.EMERG.-OFF,switch. K66	Fault with K66 relay	Check K66 emergency-stop relay in electrical control cabinet. Replace if necessary
		Wrong wiring	Check wiring.
240	Fault relay, card EMERG.-OFF, stick.K21	Error relay K21.1/K21.2	Check emergency stop relay in the electrics panel. Possibly replace
		Monitoring watch dog relay does not disengage without power	Check emergency stop relay in the electrics panel. Possibly replace
		Wrong wiring	Check wiring.
241	Fault relay, card EMERG.-OFF,switch K21	Error relay K21.1/K21.2	Check emergency stop relay in the electrics panel. Possibly replace
		Monitoring emergency stop relay does not switch	Check emergency stop relay in the electrics panel. Possibly replace
		Wrong wiring	Check wiring.
242	Fault relay, card doors, sticking K22	Error relay K22.1/K22.2	Check relay K22.1/2 in the electrics panel. Possibly replace
		Doors monitoring card, relay K22.1/2 does not disengage without power	Check relay K22.1/2 in the electrics panel. Possibly replace
		Wrong wiring	Check wiring.
243	Fault relay, card doors, switching K22	Error relay K22.1/K22.2	Check relay K22.1/2 in the electrics panel. Possibly replace
		Doors monitoring card, relay K22.1/2 does not disengage without power	Check relay K22.1/2 in the electrics panel. Possibly replace
		Wrong wiring	Check wiring.

Code	Designation Reaction/consequences	Cause	Remedy
244	Fault relay, coiler covers sticking K66	Fault, K66 relay, coiler covers	Check relay K66 in the electrics panel. Possibly replace
		Cover monitoring, K66 relay does not drop out in a de-energised state	Check relay K66 in the electrics panel. Possibly replace
		Wrong wiring	Check wiring.
245	Fault relay, coiler cover switching K66	Fault, K66 relay, coiler covers	Check relay K66 in the electrics panel. Possibly replace
		Cover monitoring, K66 relay does not switch	Check relay K66 in the electrics panel. Possibly replace
		Wrong wiring	Check wiring.
246	Fault relay, watch-dog, sticking K20	Error relay K20	Check relay K20 in the electrics panel. Possibly replace
		Monitoring watch dog relay does not disengage without power	Check watch dog relay K20 in the electrics panel. Possibly replace
		Wrong wiring	Check wiring.
247	Fault relay, watch-dog, switching K20	Error relay K20	Check relay K20 in the electrics panel. Possibly replace
		Watch dog relay does not switch	Check watch dog relay K20 in the electrics panel. Possibly replace
		Wrong wiring	Check wiring.
250	EMERG.-OFF button, card S8	Emergency shutdown button locked	Release the emergency shutdown button.
251	EMERG.-OFF button, coiler S1	Machine cannot start	Release the emergency shutdown button.
252	Door safeguard, driving side, card S18	Open doors and covers (drive)	Close doors and covers
253	Coiler, hood open S15	Open hood of coiler	Close hood.
254	Lockswitch, flat service, ON S6	Key-operated switch is in position "II" (grind card flats)	Turn key switch to position «I».
255	Lockswitch, flat service, OFF S6	Key is in position "I". (Appears only if the operating mode "Grind card flats" is selected on data screen 81.3, or if the operating mode "Test IGS-top" is selected on data screen 85.2)	Turn key switch to position «II».
257	Relay monitoring, EMERG.-OFF, card K21	Emergency stop relay disengaged	Check emergency stop relay in the electrics panel. Possibly replace
		Wrong wiring	Check wiring.
258	Relay monitoring, card doors K22	Doors monitoring, relay disengaged	Check the K22 relay in the electrical control cabinet. Replace if necessary
		Wrong wiring	Check wiring.

Code	Designation Reaction/consequences	Cause	Remedy
260	Blowroom not ready	At least one blow-room machine is not running.	Correct possible error on the corresponding machine and start the blow room.
		Firm alarm system has been actuated	Confirm fire alarm and start the plant up again.
		The rotary switch for material feed for the line at the blow room indicator board is not switch on	Switch on the rotary switch for the material feed for the line.
		The filter installation is not running.	Put the filter installation back into service.
261	Production, creep speed, stopped	Indicator that the machine produces at crawl speed	This message appears as a warning 30 seconds before the period set in data screen 40.35 elapses. Production is stopped once this period has elapsed.
262	Ends down B7	Card sliver torn	Draw in the card sliver.
263	Relay monitoring, watch-dog K20	Watch dog relay disengaged	Check watch dog relay K20 in the electrics panel. Possibly replace
		Error relay K20	Check relay K20 in the electrics panel. Possibly replace
		Wrong wiring	Check wiring.
264	MPS on, test programs	A motor protection switch other than the "Q15?" is active	Activate the "Q15?" motor protective switch, and deactivate all other motor protection switches
267	Alarm, Sliverguard USG	Incorrect Sliverguard adjustments	Make adjustments and alignments according to the Sliverguard instructions.
		Material remains on the tongue	Clean and adjust the tongue. ☞ Adjusting the distance from the tongue to the cylinder, Page 6/126
		Incorrect drafts at delivery section	Check drafts ☞ Adjust draft for take-off roll / delivery rolls, Page 6/240
		Poor lap feed	Check the lap feed.
		Infeed draft is too great	Reduce the infeed draft.
		Bad wires	Check the wires. Possibly grind or replace them. ☞ Visual checking and assessment of the cylinder wire, Page 6/321
		Delivery contaminated	Clean the delivery. ☞ Cleaning the delivery, Page 4/24, 4/28
270	D95K communication shut-down CAN A20	No feedback signal from A20 module	Check the A1, B1, C1 and C2 LEDs of the D95 K module. Check the connections of the CAN bus.
		The A1 LED of the D95K module does not light up	Check the power supply

Code	Designation Reaction/consequences	Cause	Remedy
270	D95K communication shut-down CAN A20	The C2 LED of the D95K module lights up or flashes	Check the CAN connection with the operator interface panel
271	D95K fault, software version A20	Wrong software version	Replace the A20 module Consult RIETER-Service
272	D95K data loss CAN	CAN bus connections are not in order	Check the connections of the CAN bus.
		The C2 LED of the D95K module lights up or flashes	Check the CAN connection with the operator interface panel
273	D95K fault, PROM checksum A20	Wrong check sum of the program, program is destroyed	Replace the A20 module Hold a consultation with RIETER Service
274	D95K parameter fault, CAN A20	Error in the region of the scanning rollers	Check the settings of the scanning rollers. Check the scanning gear both mechanically and pneumatically. Replace and adjust the B50 scanner for the scanning rollers. Replace and adjust the D50 quality monitor.
294	D95K fault, SRAM error A20	Defective SRAM component	Replace D95K module ☞ Changing D95K-3 module, Page 6/284 Hold a consultation with RIETER Service
305	Card A% value overshoot B6	Material remains on the tongue	Clean and adjust the tongue. ☞ Adjusting the distance from the tongue to the cylinder, Page 6/126
		Web falls from doffer and is extracted	Check condition of doffer ☞ Visual checking and assessment of the cylinder wire, Page 6/321 Grind doffer ☞ Grinding the doffer, Page 6/370
		Incorrect drafts at delivery section	Check drafts ☞ Adjust draft for take-off roll / delivery rolls, Page 6/240
		Poor lap feed	Check the lap feed.
		Delivery contaminated	Clean the delivery. ☞ Cleaning the delivery, Page 4/24, 4/28
		Card has passed the A% value	Check the cut-off limit values ☞ 22.1, Page 2/97
306	Card CV value overshoot B6	Material remains on the tongue	Clean and adjust the tongue. ☞ Adjusting the distance from the tongue to the cylinder, Page 6/126

Code	Designation Reaction/consequences	Cause	Remedy
306	Card CV value overshoot B6	Incorrect drafts at delivery section	Check drafts ☞ Adjust draft for take-off roll / delivery rolls, Page 6/240
		Poor lap feed	Check the lap feed.
		Infeed draft is too great	Reduce the infeed draft.
		Bad wires	Check the wires. Possibly grind or replace them. ☞ Visual checking and assessment of the cylinder wire, Page 6/321
		Delivery contaminated	Clean the delivery. ☞ Cleaning the delivery, Page 4/24, 4/28
		Stop limit values incorrect	Check the cut-off limit values ☞ 22.2, Page 2/97
307	Card spectrogram overshoot B6	Bad wires	Check the wires. Possibly grind or replace them. ☞ Visual checking and assessment of the cylinder wire, Page 6/321
		Non-mechanical damage to bearings	Replacing parts
		Problem with a toothed belt	Check the toothed belt and possibly replace it.
		Draft is not correct	Check the draft.
		Stop limits	Check the cut-off limit values ☞ 22.3, Page 2/98
312	Card, slubs exceeded B6	Material remains on the tongue	Clean and adjust the tongue. ☞ Adjusting the distance from the tongue to the cylinder, Page 6/126
		Incorrect drafts at delivery section	Check drafts ☞ Adjust draft for take-off roll / delivery rolls, Page 6/240
		Poor lap feed	Check the lap feed.
		Infeed draft is too great	Reduce the infeed draft.
		Bad wires	Check the wires. Possibly grind or replace them. ☞ Visual checking and assessment of the cylinder wire, Page 6/321
		Delivery contaminated	Clean the delivery. ☞ Cleaning the delivery, Page 4/24, 4/28
		Stop limit values incorrect	Check the cut-off limit values ☞ 22.2, Page 2/97
321	Slide carrier to end position B9	Sliver deposit can truck is not in the end position when the main switch is switched on	Push the can truck into the end position.

Code	Designation Reaction/consequences	Cause	Remedy
321	Slide carrier to end position B9	Wrong magnetic switch	Check magnetic switch. ☞ Notes on the magnetic limit switches on the pneumatic cylinder, Page 6/299
		Fault in the pneumatic system	Check pneumatic and valve Y6
323	Carrier malfunction B9 B10	Can truck in wrong position	Check the magnetic limit switch. ☞ Adjusting the magnetic limit switches B9, Page 6/300 ☞ Adjust magnetic limit switch B10, Page 6/301 The can truck is jammed. The pull strap for the carriage drive is torn. ☞ Changing and tightening the drive tape for the can trolley, Page 6/305 Check the pneumatics. ☞ Adjusting the throttle valves for the pneumatic cylinder of the can trolley, Page 6/304
324	Empty can missing S11	Missing empty can	Insert an empty can
326	Coiler motor overheated M1	Storage motor gets too warm	Check the entire drive of the sliver deposit for ease of operation.
327	Prod. can missing, rod switch fault S11	Missing spinning can under the turntable	Carry out a correct can change. Check the functioning of the rod switch
		No signal from the rod switch	Check the rod switch.
328	Rod sw.or carrier drive belt defect S11	No signal from the rod switch	Check the rod switch. Pull strap for the carriage drive is torn. ☞ Changing and tightening the drive tape for the can trolley, Page 6/305
362	Fault, sliver separation B13	No compressed-air to the pneumatic cylinder of sliver cutting	Check the compressed-air connections.
		Locking rod jammed	Defective pneumatic cylinder. Magnetic limit switch set incorrectly or defective. ☞ Adjust sliver cutting, production and material dependent adjustments, Page 6/309
363	Fault, sliver separation B13	No compressed-air to the pneumatic cylinder of sliver cutting	Check the compressed-air connections.

Code	Designation Reaction/consequences	Cause	Remedy
363	Fault, sliver separation B13	Locking rod jammed	Defective pneumatic cylinder. Magnetic limit switch set incorrectly or defective. ☞ Adjust sliver cutting, production and material dependent adjustments, Page 6/309
		Wrong wiring	Check wiring.
390	MPS doffer/delivery Q11 Q12	The motor protection switch has been triggered	Check drives for ease of running
		The motor protection switch keeps being triggered	Check / replace the motor.
391	MPS doffer/delivery on Q11 Q12	The motor protection switches are still switched on	The motor protection switches must not be engaged when testing the digital outputs. ☞ 82.3, Page 2/128
392	MPS card feed roll/clean.brush Q10 Q14	Motor protection switch for coiler motor has been triggered	Check the coiler drives for ease of running. Check setting for motor protection switch
		The motor protection switch keeps being triggered	Check / replace the motor.
393	MPS card f.roll/clean.br. on Q10 Q14	The motor protection switches are still switched on	The motor protection switches must not be engaged when testing the digital outputs. ☞ 82.3, Page 2/128
396	Delivery motor, max. speed reached M12	Delivery speed detection module does not work properly	Set proximity switch correctly. ☞ Adjusting the proximity switch for the delivery speed, Page 6/253, 6/277 Replace proximity switch. Check wiring for proximity switch Replace A 20 module
		Driving belt is error-prone	Check the drive belt in the delivery and replace if necessary.
397	Delivery motor, min. speed reached M12	Delivery speed detection module does not work properly	Set proximity switch correctly. ☞ Adjusting the proximity switch for the delivery speed, Page 6/253, 6/277 Replace proximity switch. Check wiring for proximity switch Replace A 20 module

Code	Designation Reaction/consequences	Cause	Remedy
398	Card feed roll, max. speed reached M10	Lap in the feed is too light	Increase the batt weight. ☞ Adjust the lap weight by the position of the card trunk wall, Page 6/32 ☞ Adjust the light barrier at the card trunk, Page 6/34 Lap feed is irregular.
		Feed scanner is not correctly adjusted	Adjust the feed scanner correctly. Replace the feed scanner. ☞ Adjust transducer in feed, Page 6/69
399	Delivery speed too high B3	Delivery speed is too high	Correctly set proximity switch or replace it ☞ Adjusting the proximity switch for the delivery speed, Page 6/253, 6/277 Replace proximity switch. Check the wiring of the proximity switch. Replace A 20 module
		Delivery speed is too high	Replace module D95K in the control system. ☞ Changing D95K-3 module, Page 6/284
400	Delivery speed too low B3	The delivery speed is too low	The delivery unit is blocked. Correctly set B3 proximity switch or replace it Check wiring for proximity switch Replace A 20 module
		Delivery speed is too high	Correctly set proximity switch or replace it ☞ Adjusting the proximity switch for the delivery speed, Page 6/253, 6/277 Replace proximity switch. Check the wiring of the proximity switch. Replace A 20 module
401	Doffer rotating speed too low B4	Delivery is not easy enough	Check the delivery for ease of action and jammed material in the delivery area
		Incorrect setting of proximity switch	Check setting ☞ Adjust the proximity switch to monitor the doffer speed, Page 6/249 Check wiring.
		A 20 module is defective	Replace A 20 module

Code	Designation Reaction/consequences	Cause	Remedy
402	Feed roll, foreign body B5	Foreign matter detected in feed section	Remove foreign matter between feed trough and feed roller ☞ Reversing the card feed roller, Page 2/48 Check feed area. Carry out functional check for transducer in feed section ☞ Adjust transducer in feed, Page 6/69
		Undermodulation for a specific control time under extreme draft ratios	Reduce lap weight at the feed area. Properly set the transducer in the feed. ☞ Adjust transducer in feed, Page 6/69
403	Scanner batt cable breakage B5	No signal from the feed plate scanner	Cable break to the scanner. Check wiring. Carry out a functionality check of the scanner. ☞ Adjust transducer in feed, Page 6/69
		Incorrect sliver weight at crawl speed	Make correct setting for sliver weight in crawl-speed mode ☞ 41.1, Page 2/106 ☞ Adjust the light barrier at the card trunk, Page 6/34
404	Scanner sliver, cable breakage B6	Current circuit to distance measuring system in delivery broken	Check wiring.
		The functioning of the distance measuring system in the delivery is not correct	Carry out a functionality test of the distance measuring system in the delivery. ☞ Check position transducer of sliver autoleveller (delivery section), Page 6/272
		A 20 (D95K) module defective	Replace A 20 module
405	Batt feeder lap too light B5	Lap in the feed is too light	Increase the batt weight. ☞ Adjust the lap weight by the position of the card trunk wall, Page 6/32 ☞ Adjust the light barrier at the card trunk, Page 6/34 Lap feed is irregular.
		Feed scanner not correctly adjusted or defective	Adjust the feed scanner correctly. ☞ Adjust transducer in feed, Page 6/69 Replace the feed scanner.

Code	Designation Reaction/consequences	Cause	Remedy
406	Batt feeder lap too heavy B5	Lap in the feed is too heavy	Reduce the card trunk depth by adjusting the card trunk wall. ☞ Adjust the lap weight by the position of the card trunk wall, Page 6/32 Adjust the light barriers on the card trunk. ☞ Adjust the light barrier at the card trunk, Page 6/34 Lap feed is irregular.
		Feed scanner not correctly adjusted or defective	Adjust the feed scanner correctly. ☞ Adjust transducer in feed, Page 6/69 Replace the feed scanner.
407	Sliver weight too light B6	Sliver weight less than 3.4/6.0 ktex (9-mm/15-mm disc roller width)	Reset draft using data screen. ☞ 41.1, Page 2/106 Set correction factor anew. ☞ 10.2, Page 2/87
		Incorrect sliver weight at crawl speed	Make correct setting for sliver weight in crawl-speed mode ☞ 41.1, Page 2/106 ☞ Adjust the light barrier at the card trunk, Page 6/34
		Poor air ratio in the delivery	Adjust the air ratio in the delivery better so that no fleece is exhausted.
		Feed section blocked	Clean feed.
408	Sliver weight too heavy B6	Sliver weight greater than 15 ktex (25 ktex)	Reset draft using data screen ☞ 41.1, Page 2/106 Set correction factor anew ☞ 10.2, Page 2/87
		Incorrect sliver weight at crawl speed	Make correct setting for sliver weight in crawl-speed mode ☞ 41.1, Page 2/106 ☞ Adjust the light barrier at the card trunk, Page 6/34
		The scanner in the delivery is either not adjusted or is defective	Adjust correctly the scanner in the delivery. ☞ Calibrating the distance measuring system in the delivery, Page 6/273 Replace the scanner in the delivery.
409	Scanner sliver, min. level cntrl. B6	Card sliver is too light	Reset draft using data screen. ☞ 41.1, Page 2/106

Code	Designation Reaction/consequences	Cause	Remedy
409	Scanner sliver, min. level cntrl. B6	Incorrect sliver weight at crawl speed	Make correct setting for sliver weight in crawl-speed mode ☞ 41.1, Page 2/106 ☞ Adjust the light barrier at the card trunk, Page 6/34
		The measured value of the distance measuring system in the card delivery stays in the lower range for too long	Adjust correctly the scanner in the delivery. ☞ Calibrating the distance measuring system in the delivery, Page 6/273 Scanner in the delivery is defective.
410	Scanner sliver, max. level cntrl. B6	Card sliver is too heavy	Reset draft using data screen. ☞ 41.1, Page 2/106
		Incorrect sliver weight at crawl speed	Make correct setting for sliver weight in crawl-speed mode ☞ 41.1, Page 2/106 ☞ Adjust the light barrier at the card trunk, Page 6/34
		The measured value of the distance measuring system at the delivery of the card stays in the upper range for too long	Adjust correctly the scanner in the delivery. ☞ Calibrating the distance measuring system in the delivery, Page 6/273 Scanner in the delivery is defective.
411	Controll. sliv. wght. under-compens.	The web does not adhere to the doffer or is partially extracted.	Reduce suction power and check doffer.
		Feed scanner not correctly adjusted	Adjust the feed scanner correctly. ☞ Adjust transducer in feed, Page 6/69
		Base draft is too small	Reset draft using data screen. ☞ 41.1, Page 2/106
		A 20 (D95K) module defective	Replace A 20 module
412	Controll. sliv. wght. over-compens.	Overmodulation for a specific control time under extreme draft ratios	The web does not adhere to the doffer or is partially suctioned off. Reduce suction and check doffer. Properly set the transducer in the delivery. ☞ Calibrating the distance measuring system in the delivery, Page 6/273
		The scanner in the delivery is not correctly adjusted	Adjust correctly the scanner in the delivery. ☞ Calibrating the distance measuring system in the delivery, Page 6/273
		Base draft is too small	Reset draft using data screen. ☞ 41.1, Page 2/106

Code	Designation Reaction/consequences	Cause	Remedy
417	Error, card configuration (43.1)	Incorrect type of card selected	Configure the card correctly ☞ 43.1, Page 2/112 Correctly configure options ☞ 43.2, Page 2/114
		Incorrect type of coiler (sliver deposit) selected	Configure the coiler (sliver deposit) correctly. ☞ 43.1, Page 2/112
		Defective reduction mechanism for M12/M11 drive units	Check M12/M11 belt pulleys (see gearing layout).
		Too much slippage for M12 driving belt	Check belt for soiling Check the belt tension
423	Doffer motor has reached max. speed M11	Target speed is too high for the doffer motor	Increase the draft in the delivery section. ☞ 41.1, Page 2/106 Reduce the delivery speed. ☞ 10.1, Page 2/86
424	Doffer motor speed too slow M11	Target speed is too low for the doffer motor	Reduce the draft in the delivery section. ☞ 41.1, Page 2/106 Increasing the speed in crawl speed mode ☞ 41.30, Page 2/153
438	Chamber wall of chute not mounted B45	No signal from B45 sensor (used for card-chute wall monitoring)	Insert card-chute wall and fix it in place with screws Connect B45 sensor using connector Carry out correct mechanical alignment of B45 sensor Check wiring
439	Chute,pressure meas., broken cable, B23	No signal from B23 pressure sensor for chute	Cable breakage at pressure sensor Check wiring Carry out functional check of pressure sensor Check jumper for pressure sensor. Calibrate the pressure sensor (zero-point calibration)
		A 20 (D95K) module defective	Replace A 20 module
440	MPS chute drives Q42 Q43	The motor protection switch has been triggered	Check drives for ease of running
		The motor protection switch keeps being triggered	Check / replace the motor.
441	MPS chute drives on Q42 Q43	The motor protection switches are still switched on	The motor protection switches must not be engaged when testing the digital outputs. ☞ 82.3, Page 2/128

Code	Designation Reaction/consequences	Cause	Remedy
442	Chute is empty B42	Card chute runs empty	Check feed machine of card line Rectify faults in the blow room Remove wound material from the feed roller/opening roller Check wiring.
		Light barrier or wiring is not OK	Check/Clean light barriers at card chute Check wiring
		Card chute runs empty	Check upstream feed machine Rectify any faults in the blow room
442	Chute is empty B23	Card chute runs empty	Check feed machine of card line Rectify faults in the blow room Remove wound material from the feed roller/opening roller Check wiring.
		B23 pressure sensor is not functioning correctly	Clean hose and discharge lines Check jumper for pressure sensor Calibrate the pressure sensor (zero-point calibration)
		Light barrier or wiring is not OK	Check/Clean light barriers at card chute Check wiring
		Card chute runs empty	Check upstream feed machine Rectify any faults in the blow room
443	Aerofeed no material	The card trunk cannot be filled	Check the AEROfeed plant. Check the card trunk for fibre accumulation. Check functioning of fill-level sensor system Check pressure sensor Clean hose and connecting discharge lines
444	Chute opening roller speed too low B44	Opening roll speed in the card trunk was too low for a short time	Increase speed of opening roller ☞ Changing the r.p.m. of the opening roller, Page 6/59 Check opening roller for wound material Correctly set proximity switch for speed monitoring. ☞ Adjusting the proximity switch for monitoring the r.p.m. of the opening roller, Page 6/58 Replace proximity switch for speed monitoring
		A 20 (D95K) module defective	Replace A 20 module

Code	Designation Reaction/consequences	Cause	Remedy
445	Chute opening roller blocked B44	Opening roller does not rotate or the r.p.m. is too low	Check opening roller for wound material Check feed roller for wound material Increase speed ☞ Changing the r.p.m. of the opening roller, Page 6/59 Correctly set proximity switch for speed monitoring ☞ Adjusting the proximity switch for monitoring the r.p.m. of the opening roller, Page 6/58 Replace the proximity switch for speed monitoring.
		A 20 (D95K) module defective	Replace A 20 module
446	Chute opening roller start-up speed B44	Opening roller in card chute does not required speed	Check opening roller for wound material Check feed roller for wound material Increase speed ☞ Changing the r.p.m. of the opening roller, Page 6/59 Correctly set proximity switch for speed monitoring ☞ Adjusting the proximity switch for monitoring the r.p.m. of the opening roller, Page 6/58 Replace proximity switch for speed monitoring
		D95K module defective	Replace D95K module ☞ Changing D95K-3 module, Page 6/284
447	Chute opening roller overheated M42	Drive, opening roll, card trunk overheated	The maximum allowable torque of the motor has been exceeded Tighten the belt and clean the belt pulley ☞ Check toothed belt and tighten (notes), Page 6/25 Check opening roller for smoothness of running
451	Chut open. roller r.p.m. too high B44	Incorrect change pulleys were fitted	Install the correct combination of change pulleys ☞ Changing the r.p.m. of the opening roller, Page 6/59 Proximity switch is defective ☞ Adjusting the proximity switch for monitoring the r.p.m. of the opening roller, Page 6/58
452	Chute door open S40	Right-hand door is open	Close the door Set limit switches

Code	Designation Reaction/consequences	Cause	Remedy
452	Chute door open S40	Wrong wiring	Check wiring.
453	MPS chute feed roll Q41	Motor protection switch for coiler motor has been triggered	Check the coiler drives for ease of running. Check setting for motor protection switch
		The motor protection switch keeps being triggered	Check / replace the motor.
454	MPS chute feed roll on Q41	The motor protection switches are still switched on	The motor protection switches must not be engaged when testing the digital outputs. ☞ 82.3, Page 2/128
455	MPS cylinder/licker-in Q1 Q13	The motor protection switch has been triggered	Check drives for ease of running
		The motor protection switch keeps being triggered	Check / replace the motor.
456	MPS cylinder/licker-in on Q1 Q13	The motor protection switches are still switched on	The motor protection switches must not be engaged when testing the digital outputs. ☞ 82.3, Page 2/128
457	Cylinder speed above 999 /min B1	Cylinder r.p.m. too high	Apply correct change gear for the cylinder drive
		Inverter defective	Replace cylinder inverter.
458	Cylinder proximity switch defective B1	Proximity switch reports a non-plausible speed change	Wait for 15 minutes if the main switch is switched on. Adjust proximity switch for monitoring the cylinder. ☞ Adjust the proximity switch for monitoring the cylinder speed, Page 6/112 Replace proximity switch for monitoring the cylinder. Check wiring.
		A 20 (D95K) module defective	Replace A 20 module
459	Cylinder speed too high B1	Incorrect change applied, for machines with drum frequency converter	Use correct change gear for cylinder drive (see gearing layout).

Code	Designation Reaction/consequences	Cause	Remedy
460	Cylinder speed too low B1	Cylinder r.p.m. below the adjusted value	clean the cylinder covered with material. Check the running of the cylinder in terms of ease of action. Clean the belt pulley. Tauten belt. Turn the cylinder by hand and then reset after the malfunction. Adjust the cut-off threshold setting for the drum ☞ 41.2, Page 2/108
461	Cylinder below production speed B1	Cylinder speed less than 390 r.p.m.	Cleaning belt pulleys. Tauten belt. ☞ Tensioning cylinder belts, Page 6/107 Check the running of the cylinder in terms of ease of action. Adjust proximity switch for monitoring the cylinder ☞ Adjust the proximity switch for monitoring the cylinder speed, Page 6/112 Replace proximity switch for monitoring the cylinder
462	Cylinder does not start up B1	Proximity switch, cylinder without pulse	Driving belt dropped in front of the belt pulley. Remove carding elements from the pre- and post-carding zones and allow the blocked cylinder to rotate again (only let the card flats run). Replace carding elements in cylinder area ☞ Changing the carding elements in the area of the cylinder, Page 6/144 Check wiring.
		A 20 (D95K) module defective	Replace A 20 module
463	Cylinder coasting, prox. sw.fault B1	Power interrupt after establishing proximity switch failure	Wait for 15 minutes if the main switch is switched on. Adjust proximity switch monitoring. ☞ Adjust the proximity switch for monitoring the cylinder speed, Page 6/112 Replace proximity switch for monitoring the cylinder.
		A 20 (D95K) module defective	Replace A 20 module

Code	Designation Reaction/consequences	Cause	Remedy
464	Cylinder fails to remain stationary B1	A 20 (D95K) module defective	Replace A 20 module
		A 20 (D95K) module defective	Replace A 20 module
465	Draft licker-in/cylinder too small	Draft between licker-in and cylinder is less than 1.15	Increase cylinder speed Reduce licker-in speed
466	Licker-in proximity switch defect. B9	Proximity switch indicates implausible speed change of the licker-in; wait 6 minutes	Clean belt pulleys. Tighten belts Check parts in the range of the licker-in unit for ease of motion. Set proximity switch for monitoring the licker-in(s). ☞ Adjust the proximity switch for monitoring the licker-in speed, Page 6/90 Replace proximity switch for monitoring the licker-in(s).
		A 20 (D95K) module defective	Replace A 20 module
467	Licker-in rot. speed not reached B9	R.p.m. of licker-in not achieved	Cleaning belt pulleys. Tauten belt. ☞ Tauten the licker-in belts, Page 6/88 Check parts in the region of the licker-in group for easy motion. Adjust proximity switch for monitoring the licker-in speed. ☞ Adjust the proximity switch for monitoring the licker-in speed, Page 6/90 Replace proximity switch for monitoring the licker-in speed.
		A 20 (D95K) module defective	Replace A 20 module
468	Licker-in blocked B9	R.p.m. of licker-in too low	Cleaning belt pulleys. Tauten belt. ☞ Tauten the licker-in belts, Page 6/88 Check parts in the region of the licker-in group for easy motion. Adjust proximity switch for monitoring the licker-in speed. ☞ Adjust the proximity switch for monitoring the licker-in speed, Page 6/90 Replace proximity switch for monitoring the licker-in speed.

Code	Designation Reaction/consequences	Cause	Remedy
469	Licker-in rotating speed too low B9	R.p.m. of licker-in too low	Cleaning belt pulleys. Tauten belt. ☞ Tauten the licker-in belts, Page 6/88 Check parts in the region of the licker-in group for easy motion. Adjust proximity switch for monitoring the licker-in speed. ☞ Adjust the proximity switch for monitoring the licker-in speed, Page 6/90 Replace proximity switch for monitoring the licker-in speed.
470	Congestion, flat cleaning B11	Suction canal for receiving card-flat waste is blocked	Clean suction lines
		Light barrier/Reflector is soiled	Clean light barrier/reflector Align light barrier/reflector ☞ Reflex light barrier for monitoring the suction of the card flats waste, Page 6/190 Increase setting for length of time until fault indication ☞ 41.32, Page 2/155
		Light barrier defective	Light barrier defective; replace it
471	Flat alignment faulty B8	Skew running belts of the card flats	Realign the card flats Set proximity switches for card flats on left and right ☞ Adjust the proximity switch for monitoring the smooth running of the card flats., Page 6/199 Check wiring
		Fault with proximity switches used for monitoring	Set, synchronise or replace proximity switches ☞ Adjust the proximity switch for monitoring the smooth running of the card flats., Page 6/199
		Contact surfaces insufficiently lubricated	Replace lubricating block
472	Flat standstill B2	Standstill of card flats indicated	Remove any dirt in the card-flat section Correctly fix in place any loose or jammed card flats
		Fault with proximity switches used for monitoring	Set, synchronise or replace proximity switches ☞ Adjust the proximity switch for monitoring the smooth running of the card flats., Page 6/199

Code	Designation Reaction/consequences	Cause	Remedy
472	Flat standstill B2	Contact surfaces insufficiently lubricated	Replace lubricating block
473	Low suction S3	Central suction is blocked	Check and clean the entire central suction.
		Hose between measuring point and differential pressure switch is blocked	Clean the hose.
		Vacuum lower than the set value	Check differential pressure switch
		Defective differential pressure switch	Replace differential pressure switch
		Tube diameter is too small	Exchange tube from the central suction system to the machine for a larger one.
		Input at I/O module defective	Replace respective I/O module
474	Cylinder not stopped B1	Error occurs while braking	Belt is no longer on the belt pulley. Clean the belt and the belt pulley. Tighten if necessary. ☞ Tensioning cylinder belts, Page 6/107
		The cylinder proximity switch does not signal the cylinder still-stand	Adjust proximity switch for monitoring the cylinder. ☞ Adjust the proximity switch for monitoring the cylinder speed, Page 6/112 Replace proximity switch for monitoring the cylinder.
475	Cylinder speed not reached B1	Cylinder speed less than 390 r.p.m.	Cleaning belt pulleys. Tauten belt. ☞ Tensioning cylinder belts, Page 6/107 Check the running of the cylinder in terms of ease of action. Adjust proximity switch for monitoring the cylinder ☞ Adjust the proximity switch for monitoring the cylinder speed, Page 6/112 Replace proximity switch for monitoring the cylinder

Code	Designation Reaction/consequences	Cause	Remedy
476	Cylinder speed not reached B1	Proximity switch, cylinder without pulse	Driving belt dropped in front of the belt pulley. Remove carding elements from the pre- and post-carding zones and allow the blocked cylinder to rotate again (only let the card flats run). Replace carding elements in cylinder area ☞ Changing the carding elements in the area of the cylinder, Page 6/144 Check wiring.
477	Configuration fixed flats X1.3 A31	Incorrect type of card flats	The type of card flats installed was configured incorrectly. ☞ 43.1, Page 2/112
		Incorrect wiring for option "fixed flats" (stationary card flats).	Run wire from A31 terminal X1/3 to terminal 301.
478	Configuration fixed flats X1.3 A32	Incorrect type of card flats	The type of card flats installed was configured incorrectly. ☞ 43.1, Page 2/112
		Incorrect wiring for option "fixed flats" (stationary card flats).	Run wire from terminal X1/3 of A32 to terminal 300.
479	Licker-in lift.cyl.pos.not reached M29	Incorrect position	Check mechanical default setting of lift cylinder
		Incorrect wiring	Check wiring.
480	Licker-in lift.cylinder.ref.positon M29	Incorrect position	Check mechanical default setting of lift cylinder
		Incorrect wiring	Check wiring.
481	Licker-in lift.cylinder cable break D13	Broken cable between lifting cylinder and A20 module	Check wiring.
482	Cylinder motor overheated M1	Cylinder motor has overheated	The maximum torque of the motor was exceeded. Tighten the belts and clean the belt pulley. ☞ Tensioning cylinder belts, Page 6/107 Check cylinder for smooth running. Check the clothings condition in the area of the cylinder

Code	Designation Reaction/consequences	Cause	Remedy
483	Licker-in rotating speed too high B9	Incorrect change pulleys were fitted	Install the correct combination of change pulleys. ☞ Change the licker-in speed, Page 6/87 Proximity switch is defective ☞ Adjust the proximity switch for monitoring the licker-in speed, Page 6/90
484	MPS, flats, drives, Q50 Q57 Q58	A motor protection switch has been triggered	Check the motors and rollers for ease of motion
485	IGS-cl. proximity sw. position left B51	IGS-classic: No signal when the guide carriage is on the left-hand side of the machine	Move the guide carriage to the right position (data screen 85.1). Replace proximity switch Check wiring. Check the setting and position of the grinding stone. ☞ Adjust the grinding stone if the electrical magnet was replaced., Page 6/163 Check the mechanism. Clean the interior of the IGS. ☞ Removing the guiding sled, Page 6/154 Defective sealing lips.
486	IGS-cl. proximity sw.position right B52	IGS-classic: No signal when the guide carriage is on the right-hand side of the machine	Replace proximity switch. Check wiring. Check the setting and position of the grinding stone. ☞ Adjust the grinding stone if the electrical magnet was replaced., Page 6/163 Check the mechanism.
487	IGS-classic not in park position B52	IGS-classic: Guide carriage not at the starting position	Check the drive. Move the guide carriage to the starting position (parking position) on the right-hand side of the machine (data screen 85.1).
488	MPS, flats, drives on, Q50,Q57,Q58	The motor protection switches are still switched on	The motor protection switches must not be engaged when testing the digital outputs. ☞ 82.3, Page 2/128
489	IGS-classic grindstone position S53	The grinding stone does not reach the grinding position.	Check for mechanical defects in the grinding stone area.

Code	Designation Reaction/consequences	Cause	Remedy
489	IGS-classic grindstone position S53	The electromagnet is defective	Replacing the electromagnet. ☞ Remove the electromagnet, Page 6/161 ☞ Install the electromagnet, Page 6/162 Adjust the grinding stone if the electrical magnet was replaced. ☞ Adjust the grinding stone if the electrical magnet was replaced., Page 6/163
		No signal issued by the proximity switch that monitors the position of the grinding stone.	Replace and set the proximity switch.
490	MPS power supply 24 VDC F2	Circuit breaker has tripped, overload in 24 VDC power supply	Check licker-in lifting cylinder Check IGS-classic motor. Check circulation fan in control cabinet.
		Short circuit in 24 VDC power supply	Individually check 24 VDC power supply consumers.
491	MPS power supply 24 VDC on F2	The motor protection switches are still switched on	The motor protection switches must not be engaged when testing the digital outputs. ☞ 82.3, Page 2/128
492	MPS IGS-top grinding drive Q55	Motor protection switch for coiler motor has been triggered	Check the coiler drives for ease of running. Check setting for motor protection switch
		IGS-top grinding pressure is too high	Check IGS-top grinding pressure. ☞ Check current consumption (with grinding brush contact on the card flats clothing), Page 6/228
		The motor protection switch keeps being triggered	Check / replace the motor.
493	MPS IGS-top grinding drive on Q55	The motor protection switches are still switched on	The motor protection switches must not be engaged when testing the digital outputs. ☞ 82.3, Page 2/128
494	IGS-classic motor fails to start M51	Defective drive	Check the drive for mechanical defects
		Operating pressure not reached	Check air conditions and connections. Check the operating pressure of the card.
495	IGS-top cable breakage, curr. meas. D55	Cable breakage	Replace cable. Check the D 55 current transformer and replace it, if necessary.
		A 20 (D95K) module defective	Replace A 20 module

Code	Designation Reaction/consequences	Cause	Remedy
496	IGS-top grinding force too high	Setting the grinding brush	Check the position of the grinding brush. ☞ Check the position of the grinding brush, Page 6/230 Check the current consumption. ☞ Check current consumption (with grinding brush contact on the card flats clothing), Page 6/228
497	Malfunction suction licker-in S9	Central suction is blocked	Check and clean the entire central suction.
		Hose between measuring point and differential pressure switch is blocked	Clean the hose.
		Vacuum lower than the set value	Check differential pressure switch
		Defective differential pressure switch	Replace differential pressure switch
		Tube diameter is too small	Exchange tube from the central suction system to the machine for a larger one.
		Input at I/O module defective	Replace respective I/O module
498	Flats clear.roller1,contactor forw. K56	K56 contactor does not work	Check K56 contactor Check "U50 - K56 - A20" wiring
		MA/MB/MC relay at U50 converter defective	Replace U50 converter
500	Chute f.roll FC parameter incorrect U41 Reaction The fault messages are identical for all frequency converters used. The electrical designations of the affected frequency converters are indicated in the text display. (U1, U3, U10, U11, U12, U13, U41, U50, U60 and U80)	Inverter programming defective	Check the terminating resistor of the CAN bus ☞ Set or wire the terminators., Page 6/387
		CAN bus frequency inverter defective	Replace CAN bus module of converter
		Inverter defective	Replace inverter. ☞ Replacing the frequency converter, Page 6/378
		Wrong inverter type fitted	Fit correct inverter type.
		Communication interrupted	Check wiring. Check communication addresses. Check address and baudrate ☞ Setting the T1000V frequency converter, Page 6/385 ☞ Configuring the frequency inverter, Page 6/383 Replace CAN bus module
501	Chute f.roll FC,communicat.shutdown U41	Inverter programming defective	Check the terminating resistor of the CAN bus ☞ Set or wire the terminators., Page 6/387

Code	Designation Reaction/consequences	Cause	Remedy
501	Chute f.roll FC,communicat.shutdown U41	CAN bus frequency inverter defective	Replace CAN bus module on the frequency inverter.
		Inverter defective	Replace inverter. ☞ Replacing the frequency converter, Page 6/378
		Wrong inverter type fitted	Fit correct inverter type.
		Communication interrupted	Check wiring. Check communication addresses. Check address and baudrate ☞ Setting the T1000V frequency converter, Page 6/385 ☞ Configuring the frequency inverter, Page 6/383 Replace CAN bus module
502	Chute f.roll FC CAN node stat. inc. U41	Inverter programming defective	Check the terminating resistor of the CAN bus ☞ Set or wire the terminators., Page 6/387
		Inverter defective	Replace inverter. ☞ Replacing the frequency converter, Page 6/378
		Wrong inverter type fitted	Fit correct inverter type.
		Communication interrupted	Check wiring. Check communication addresses. Check address and baudrate ☞ Setting the T1000V frequency converter, Page 6/385 ☞ Configuring the frequency inverter, Page 6/383 Replace CAN bus module
503	Chute f.roll FC mot.overcurrent M41 U41	Motor overloaded	Check the machine part being driven under light running conditions.
		Wrong wiring	Check wiring.
		Motor defective	Replace the motor.
504	Chute f.roll FC converter overload U41	Load is too high. Ramp-up, ramp-down and switching-on times are too short.	Check the load, the lengths of run-up and run-down times and the switching-on time.
		Motor overloaded	Check the machine part being driven under light running conditions.
		Belts insufficiently tensioned	Tauten belt. Check the belt tension.
		Wrong wiring	Check wiring.
508	Chute f.roll FC conv. earth fault U41	Short to earth due to worn insulation or fire damage	Check the cabling for insulation damage or other damage.

Code	Designation Reaction/consequences	Cause	Remedy
510	Chute f.roll FC phase fail.p.supply U41	Poor electrical network	Check the pre-fusing of the network and line power.
		Inverter defective	Replace inverter. ☞ Replacing the frequency converter, Page 6/378
511	Chut.f.roll FC interm.circ.overvolt.U41	Mains voltage supply too high	Check mains voltage supply.
512	Chu.f.roll FC interm.circ.undervolt.U41	Short-term mains power supply breakdown or the variations in the mains are too high.	Guarantee that the mains power supply is more stable.
		Mains power voltage too low	Check mains voltage supply.
		Missing phase	Connect missing phase.
513	Chute f.roll FC loading cont.faulty U41	Charging contactor has failed	Test switching off and switching on the power supply.
		Energizing coil of the charging contactor is burned out	Replace the frequency inverter.
514	Chute f.roll FC inter. phase output U41	Cable to motor is broken	Check the wires of the cable connection to the motor. Connect the output terminals correctly. Check the motor windings.
		Too low motor power	Check motor and frequency inverter power.
515	Chute f.roll FC overheating, h.sink U41	Cooling duct not connected	Connect the cooling channel at the rear side of the control cabinet.
		Cooling duct blocked	Clean the cooling channel at the rear side of the control cabinet.
		Insufficient cooling	Lower ambient temperature.
		No heat-conductive paste has been applied	Apply heat-conductive paste between inverter and heat sink. ☞ Adjusting to the cooling system, Page 6/384
520	Chute f.roll FC,fault,brake.transis.U41	Charging contactor has failed	Test switching off and switching on the power supply.
		Retarding transistor is defective	Replace the frequency inverter.
521	Chute f.roll FC, ext.fault chain U41	Inverter programming defective	Check the terminating resistor of the CAN bus ☞ Set or wire the terminators., Page 6/387
		Inverter defective	Replace inverter. ☞ Replacing the frequency converter, Page 6/378

Code	Designation Reaction/consequences	Cause	Remedy
522	Chute f.roll FC motor overheating M41	Inverter programming defective	Check the terminating resistor of the CAN bus ☞ Set or wire the terminators., Page 6/387
		Inverter defective	Replace inverter. ☞ Replacing the frequency converter, Page 6/378
527	Chute f.roll FC,fault,optional card U41	The option board is not correctly connected.	Switch off the power supply and plug the board in again.
		Option board is defective	Replace the options board.
537	Chute f.roll FC conv.hardware fault U41	Inverter programming defective	Check the terminating resistor of the CAN bus ☞ Set or wire the terminators., Page 6/387
		Inverter defective	Replace inverter. ☞ Replacing the frequency converter, Page 6/378
		Control circuit is damaged	Test switching off and switching on the power supply. If the fault occurs again the frequency inverter must be replaced.
540	Chute f.roll FC, wrong conv. type U41	Wrong inverter type fitted	Fit correct inverter type.
541	Chute f.roll FC, unrecognised fault U41	Inverter programming defective	Check the terminating resistor of the CAN bus ☞ Set or wire the terminators., Page 6/387
		Inverter defective	Replace inverter. ☞ Replacing the frequency converter, Page 6/378
		Communication interrupted	Check wiring. Check communication addresses. Check address and baudrate ☞ Setting the T1000V frequency converter, Page 6/385 ☞ Configuring the frequency inverter, Page 6/383 Replace CAN bus module

2.2 Warning

Code	Designation Reaction/consequences	Cause	Remedy
551	Low battery A10	Battery empty	Replace the battery. ☞ Change battery of control system, Page 6/375
560	EMERG-OFF button card, EMERG-OFF tst	Emergency stop circuit blocked	Test for emergency stop circuit cannot be carried out.
		Emergency shutdown button locked	Release the emergency shutdown button.
		Wrong wiring	Check wiring.
561	Lock doors, test EMERG-OFF circuit	Emergency stop circuit blocked	Test for emergency stop circuit cannot be carried out.
		Door open	Close door.
		Open covers	Close the covers.
		Wrong wiring	Check wiring.
574	D95K Spectrogram inactive III	Not all parameter values for the A20 module lie within valid ranges	Replace the A20 module Consult RIETER-Service
576	Prox. switch, carrier centre defect B16	The magnetic switch for activation of the positioning levers does not switch	Check magnetic switch, replace if necessary
576	Prox. switch, carrier centre defect B16	The middle magnetic limit switch does not switch	Check the middle magnetic limit switch.
580	Prox. switch, carrier centre defect B8	The magnetic switch for activation of the positioning levers does not switch	Check magnetic switch, replace if necessary
581	Sliver cutting delay	Incorrect sliver separation procedure	Set time for sliver separation ☞ Adjust sliver cutting, time at which the piston rod extends, Page 6/308 Incorrect sliver separation procedure Check settings. ☞ Adjust sliver cutting, production and material dependent adjustments, Page 6/309 Check procedure settings (time out) ☞ 42.3, Page 2/111
596	Standard draft too small	The web does not adhere to the doffer or is partially extracted.	Reduce suction power and check doffer.
		Feed scanner not correctly adjusted	Adjust the feed scanner correctly. ☞ Adjust transducer in feed, Page 6/69
		Feed trough in card feed section is jammed	Check the feed trough for ease of movement

Code	Designation Reaction/consequences	Cause	Remedy
596	Standard draft too small	Feed scanner is not correctly adjusted	Adjust the feed scanner correctly. Replace the feed scanner. ☞ Adjust transducer in feed, Page 6/69
		Base draft is too small	Reset draft using data screen. ☞ 41.1, Page 2/106
597	Standard draft too large	Lap in the feed is too heavy	Reduce the card trunk depth by adjusting the card trunk wall. ☞ Adjust the lap weight by the position of the card trunk wall, Page 6/32 Adjust the light barriers on the card trunk. ☞ Adjust the light barrier at the card trunk, Page 6/34 Lap feed is irregular.
		Feed trough in card feed section is jammed	Check the feed trough for ease of movement
		Feed trough in card feed section is jammed	Check the feed trough for ease of movement
		Feed scanner is not correctly adjusted	Adjust the feed scanner correctly. Replace the feed scanner. ☞ Adjust transducer in feed, Page 6/69
601	Chute photocells soiled B43	The light barrier at the card trunk is not receiving a signal	Clean card chute window ☞ Clean the light barriers at the card trunk, Page 4/22 Align the light barrier.
604	IGS-classic solenoid cooling	Lifting magnet too hot for further cycles	Wait until the lifting magnet has cooled down.
606	IGS-cl. max. grinding cycles reached	IGS classic: Programmed number of grinding cycles reached	Check the cylinder wire. Increase the service life (durability) of the clothing is cylinder clothing is still usable. ☞ 41.3, Page 2/109 ☞ Changing the prescribed service life of the cylinder clothing, Page 6/151 Press on new cylinder wire. Reset data mask. ☞ 70.1, Page 2/120 Replace the grinding stone. ☞ Removing the grinding stone, Page 6/160 ☞ Installing the grinder, Page 6/150

Code	Designation Reaction/consequences	Cause	Remedy
607	IGS-classic cycle incomplete B51	IGS classic: Incompletely executed grinding cycle	Check the pneumatics. Belt tension for the guide carriage is too low. ☞ Slackening and tightening the flat belt (system with tension screws), Page 6/158 Check the mechanism. Remove trapped material from around the guide-carriage belt.
608	IGS-classic inactive (fault)	IGS classic no longer active	Check the pneumatics. Belt tension for the guide carriage is too low. ☞ Slackening and tightening the flat belt (system with tension screws), Page 6/158 Check the mechanism. Remove trapped material from around the guide-carriage belt.
609	IGS-top max. grinding cycles reached	IGS top: Programmed number of grinding cycles reached	Inspect the clothing of the card flats Check the IGS top mechanics. Programme additional grinding cycles if the clothing of the card flats can still be used. ☞ 41.3, Page 2/109 Replace the set of card flats. Reset data mask. ☞ 70.1, Page 2/120 Replace grinding brushes. ☞ Install grinding brush, Page 6/227
610	IGS-top cycle aborted	Cylinder was stopped during the grinding cycle	The cycle continues automatically after starting
		Motor protection switch "Q55" was triggered during the grinding cycle.	Check IGS-top default setting. ☞ Adjust grinding brush parallelism to card flats (default setting), Page 6/232 ☞ Adjust grinding pressure, Page 6/234 Check IGS-top current consumption. ☞ Check current consumption (with grinding brush contact on the card flats clothing), Page 6/228
611	Licker-in lift. cylinder blocked M29	Blocked lift cylinder when checking in the test program	Check mechanics of mote knife adjustment mechanism. (Default setting).

Code	Designation Reaction/consequences	Cause	Remedy
612	IGS-top grinding force too high	Setting the grinding brush	Check the position of the grinding brush. ☞ Check the position of the grinding brush, Page 6/230 Check the current consumption. ☞ Check current consumption (with grinding brush contact on the card flats clothing), Page 6/228
613	IGS-top grinding force too low	Setting the grinding brush	Check the position of the grinding brush. ☞ Check the position of the grinding brush, Page 6/230 Check the current consumption. ☞ Check current consumption (with grinding brush contact on the card flats clothing), Page 6/228
614	IGS-top inactive (fault)	Checking states and settings	Check mechanical settings. ☞ Adjust grinding brush parallelism to card flats (default setting), Page 6/232 ☞ Adjust grinding pressure, Page 6/234 Check the pneumatic system.
		Setting the grinding brush	Check the position of the grinding brush. ☞ Check the position of the grinding brush, Page 6/230 Check the current consumption. ☞ Check current consumption (with grinding brush contact on the card flats clothing), Page 6/228
615	Wait until flat clean.monitor. act. B11	Light barrier/Reflector is soiled	Clean light barrier/reflector Align light barrier/reflector ☞ Reflex light barrier for monitoring the suction of the card flats waste, Page 6/190 Increase setting for length of time until fault indication ☞ 41.32, Page 2/155
616	Carding gap measurement, position 1	Take measurements for card flats (measurement points 50 - 54)	The card flats are moved to the respective measurement points.
617	Carding gap measurement, position 2	Take measurements for card flats (measurement points 50 - 54)	The card flats are moved to the respective measurement points.

Code	Designation Reaction/consequences	Cause	Remedy
618	Carding gap measurement, position 3	Take measurements for card flats (measurement points 50 - 54)	The card flats are moved to the respective measurement points.
619	Carding gap measurement, position 4	Take measurements for card flats (measurement points 50 - 54)	The card flats are moved to the respective measurement points.
620	Carding gap measurement, position 5	Take measurements for card flats (measurement points 50 - 54)	The card flats are moved to the respective measurement points.

2.3 Maintenance warning

Code	Designation Reaction/consequences	Cause	Remedy
621	Meas. pos. approach, carding gap	Move the card flat to the respective measurement point	The card flat is moved to the respective measurement point.
622	Lt. barr., flat clean.unit, soiled, B11	Light barrier in card-flats waste chamber is soiled	Clean the light barrier and waste chamber

3 Error not displayed

3.1 Card chute

3.1.1 Conveyance of material to the card chutes

Cause	Remedy
Card chutes are running without material	Increase differential pressure in feed duct, so that more material is fed ☞ Setting the differential pressure switch (standard setting), Page 6/37 Increase the production rate of the feed machine

3.1.2 Card chute, unsatisfactory filling

Cause	Remedy
Supplied deflector not fitted at first card chute.	Fit the deflector. ☞ Fitting and setting the deflection plate at the first card chute, Page 6/29
Material deposit in feed duct	Remove cover and clean duct ☞ Remove any material deposited in the card trunk., Page 4/23
Feed duct is blocked	Rectify problem with poorly-fitted joints in feed duct ☞ Cleaning the feed duct, Page 4/21

3.1.3 Problems in the vicinity of the opening unit

Cause	Remedy
Drive, opening roll, card trunk overheated	The maximum allowable torque of the motor has been exceeded Tighten the belt and clean the belt pulley ☞ Check toothed belt and tighten (notes), Page 6/25 Check opening roller for smoothness of running
Incorrect change pulleys were fitted	Install the correct combination of change pulleys ☞ Changing the r.p.m. of the opening roller, Page 6/59 Proximity switch is defective ☞ Adjusting the proximity switch for monitoring the r.p.m. of the opening roller, Page 6/58

3.2 Cylinder grinding system IGS-classic

3.2.1 The grinding stone in the grinder of the IGS classic does not move

Cause	Remedy
The guiding sled is not in its parking position on the right-hand side of the machine	Bring the guiding sled into its parking position. ☞ IGS test run, Page 6/153
The movement is being hindered by a mechanical cause in the guiding sled.	Check the guiding sled and possibly remove and install it again. ☞ Removing the guiding sled, Page 6/154 ☞ Installing the guiding sled, Page 6/155
The diode in the socket for connecting to the cylinder grinding system is defective.	Replace the diode.
The electromagnet is defective	Replacing the electromagnet. ☞ Remove the electromagnet, Page 6/161 ☞ Install the electromagnet, Page 6/162 Adjust the grinding stone if the electrical magnet was replaced. ☞ Adjust the grinding stone if the electrical magnet was replaced., Page 6/163

3.3 CAN IO module CX408

3.3.1 LED "status" on module CX408 does not light up green

Cause	Remedy
CAN I/O module may be faulty	Check module and possibly replace. ☞ Checking CAN I/O module CX408, Page 6/388

3.4 Frequency converter

3.4.1 Frequency inverter, no reaction

Cause	Remedy
No power	Check the supply voltage and re-connect if necessary. See electrical manual.
Hardware defective	The equipment has be replaced. ☞ Replacing the frequency converter, Page 6/378 The equipment has to be configured. ☞ Loading the frequency inverter, Page 6/382 ☞ Configuring the frequency inverter, Page 6/383 ☞ Adjusting to the cooling system, Page 6/384